

Work Order ID 82722

\*82722\*

Page 1

Thursday, April 05, 2012 12:57:36 PM

Item ID: D135-751-011

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube Installation

Start Date: 4/5/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date: 12045 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

Handwritten notes: 12-5-8, 12-05-01, and other markings.

Large handwritten number: 882722

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 82722****\*82722\***

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Start Date: 4/5/2012 Start Qty: 1.00

**\*1\***

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Required Date: 4/13/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

**\*120\***

Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft &amp; Fwd Cap holes using DT8678 &amp; DT8901

4-Locate DT8870 &amp; Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. \*\*\*\*DO NOT OPEN AFT CAP HOLES\*\*\*\*

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft &amp; Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 &amp; Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

SAD 12-04-18

SAD 12-04-17

SAD 12-04-17

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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**Work Order ID 82722****\*82722\***

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*Handwritten signature and date 12-4-19**Handwritten signature and date 12-4-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item Name: Skidtube Installation

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Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

**\*170\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) &amp; .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 &amp; QSI 015

A/R 241 Sike Flex Batch: 12/22/1  
Exp Date: 13/6/164  
start time: 10:15  
end time: 12/04/25

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C &amp; D-D.

A/R AL ROD Batch: 11/20/164

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&amp;B

8-Deburr Rivet holes.

DC 12/04/19

DC 12/04/23

DC 12/04/25

DC 12-4-26

W/O:		WORK ORDER CHANGES					
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**\*82722\***

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Thursday, April 05, 2012 12:57:36 PM

Item ID: DI35-751-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Installation

Start Date: 4/5/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Run Start **\*NR1\***

Stop **\*NR2\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC10- Inspect visual per QS1004- ground welds

0.00

**\*180\***

QC

Memo

0.00

Quality Control

*1/1* *12-04-26*

190

Skidtubes

0.00

**\*190\***

Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

*100 12-4-26*

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

*5/26/30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*82722\*

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\*NS2\*

Item Name: Skidtube Installation

Start Date: 4/5/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/13/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start

\*NR1\*

Stop

\*NR2\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

Pressure Wash per QSI005 4.3

0.00

\*210\*

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

*Handwritten:* 12-4-30

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*220\*

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*Handwritten:* 8-20  
320 OF  
8-50

*Handwritten:* 12/5/01

230

QC3- Inspect Part Finish

0.00

\*230\*

QC

Memo

0.00

Quality Control

*Handwritten:* 1 x d nlos/c

*Handwritten:* M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 82722****\*82722\***

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

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Item Name: Skidtube Installation

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**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

**\*260\***

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

0.00

✓ 1- Install Wearplate &amp; Ground Wire inserts as per Dwg D3507.

✓ 1- Inspect for Foreign objects

✓ 2- Install Fwd &amp; Aft caps as per Dwg D3507 And Detail "A" &amp; "B"

A/R 241 Sika Flex Batch: AA121221  
Exp Date: 13161

✓ 3- Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube  
Do not Install Screws where indicated on Dwg (Note #6)✓ A/R 241 Sika Flex Batch: AA121221  
Exp Date: 13161

✓ 4- assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: AA110349

✓ 5- Wing Walk as per Dwg D3507 and Q3I 005 4.4

Batch: AA1211211x q 21 u108101

W/O:		WORK ORDER CHANGES					
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**Work Order ID 82722****\*82722\***

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
<b>*270*</b>									
QC	Memo	0.00							
Quality Control									
280	Pick Kit	0.00							
<b>*280*</b>									
Packaging	Memo	0.00							
Packaging									
290	QC4- 100% Inspect kits for completeness	0.00							
<b>*290*</b>									
QC	Memo	0.00							
Quality Control									

12:05 09 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, April 05, 2012 12:57:36 PM

**\*82722\***

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Item ID: D135-751-011

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Revision ID:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

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Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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300

0.00

**\*300\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-751-011

Location: \_\_\_\_\_

PPP Rev: B

310

QC21- Final Inspection - Work Order Release

0.00

**\*310\***

QC

Memo

0.00

Quality Control

12-5-9

12/5/10

MCS 12/05/09

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Page 1

Thursday, April 05, 2012 12:57:41 PM

Work Order ID: 82722

\*82722\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM  
 IPP Rev:B 06-12-18 As per Rev B JLM  
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD  
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD  
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F  
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17  
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130

Purchased

No

Each

318.0000

38

\*AI S7-1032-130\*

AL54-1032-130

11120837

\*\*

(X38)

12/05/01

Insert

Location

Loc Qty

Loc Code

ST280

165

117717

27

118966

22

119775

116

ST282

153

119530

73

120181

80

D3507-1-BENT

Manufactured

No

120

Each

7.0000

1

\*D3507-1-BENT\*

\*\*

1

12-04-17

Skidtube Assembly EC135

Location

Loc Qty

Loc Code

LG

7

75264

2

75265

2

77441

1

77443

2

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each 21.0000 2 2

\*D3504-1\*

Crossbolt Spacer

\*\*

BE 12/04/25  
882725 \*2

Location

Loc Qty

Loc Code

LG001

21

53742

2

75240

19

D3504-3 Manufactured No

170 Each 11.0000 1 1

\*D3504-3\*

Crossbolt Spacer

\*\*

BE 12/04/25  
882726 \*1

Location

Loc Qty

Loc Code

LG001

11

53743

11

D3504-5 Manufactured No

170 Each 15.0000 2 2

\*D3504-5\*

Crossbolt Spacer

\*\*

BE 12/04/25

Location

Loc Qty

Loc Code

LG001

15

76239

15

D3505-1 Manufactured No

170 Each 3.0000 1 1

\*D3505-1\*

Web

\*\*

BE 12/04/23

Location

Loc Qty

Loc Code

LG

2

75256

2

LG001

1

75211

1

Thursday, April 05, 2012 12:57:41 PM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 3

Thursday, April 05, 2012 12:57:41 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3506-1 Manufactured No

190

Each

44.0000

4

4

\*\*

*OK/C 12-4-26*

**\*D3506-1\***

Doubler

Location

Loc Qty

Loc Code

ST051

44

8

36

190

Each

57.0000

2

2

\*\*

*OK/C 12-4-26*

D3506-3 Manufactured No

**\*D3506-3\***

Doubler

Location

Loc Qty

Loc Code

ST051

57

57

190

Each

2,172.000

12

\*\*

*OK/C 12-4-26*

MS20601-AD4W3 Purchased No

**\*MS20601-AD4W3\***

Rivet

Location

Loc Qty

Loc Code

ST321

2172

2172

*OK/C 12-4-26*

Thursday, April 05, 2012 12:57:41 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, April 05, 2012 12:57:41 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

260

Each

2,469.000

1

1

**\*ALS4-1032-225\***

**\*\***

*yl 12/05/01*

Insert

Location

Loc Qty

Loc Code

ST281

2446

*X1120837*

108696

146

110768

62

118386

55

118966

68

120671

115

121269

2000

*yl*

ST282

23

120410

10

120451

13

AN3C4A

Purchased

No

260

Each

3,020.000

31

31

**\*AN3C4A\***

**\*\***

*yl 12/05/01*

BOLT

Location

Loc Qty

Loc Code

ST350

3020

120187

1982

*X31*

120769

38

121205

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

Page 5

Thursday, April 05, 2012 12:57:42 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

260

Each

1,600.000

2

2

**\*AN3C5A\***

Bolt

\*\*

*M 12/05/01*

## Location

## Loc Qty

## Loc Code

FP001

7

*M 121068*

*x2*

115835

7

ST350

1593

116419

28

117343

13

117764

7

117872

2

119749

23

120423

520

1210168

500

121255

500

AN526C1032R10

Purchased

No

260

Each

219.0000

2

2

**\*AN526C1032R10\***

Screw

\*\*

*M 12/05/01*

## Location

## Loc Qty

## Loc Code

FP002

79

108062

79

*y2*

ST348

140

110049

40

114494

100

AN960C10L

NAS1149C0332  
R

Purchased

No

260

Each

0.0000

33

33

**\*AN960C10L \*** *X*

washer

*M 121509*

\*\*

*(x33) M 12/05/01*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Thursday, April 05, 2012 12:57:42 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D2965      Manufactured      No      260      Each      59.0000      1      1

**\*D2965\***

Cap, 105 Skidtube

\*\*

HL 12/05/01

Location	Loc Qty	Loc Code
FP002	59	
71371	9	
80089	50	

FP002

59

71371

9

80089

50

D2965-3      Manufactured      No      260      Each      8.0000      1      1

**\*D2965-3\***

Cap

\*\*

HL 12/05/01

Location	Loc Qty	Loc Code
FP002	8	
50560	1	
75254	7	

FP002

8

50560

1

75254

7

D3492-1      Manufactured      No      260      Each      30.0000      4      4

**\*D3492-1\***

Plug

\*\*

HL 12/05/01

Location	Loc Qty	Loc Code
FP002	30	
69531	8	
74444	2	
76235	4	
77037	16	

FP002

30

69531

8

74444

2

76235

4

77037

16

D3492-3      Manufactured      No      260      Each      1.0000      4      4

**\*D3492-3\***

Plug

\*\*

HL 12/05/01

Location	Loc Qty	Loc Code
FP-A	1	
78600	1	

FP-A

1

78600

1

383098

383099

x4

x4

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

Thursday, April 05, 2012 12:57:42 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-7

Manufactured No

260

Each

32.0000

2

2

**\*D3492-7\***

Plug

\*\*

yl 12/05/01

Location

Loc Qty

Loc Code

FP002

32

71881

8

77222

24

yl

D3508-1

Manufactured No

260

Each

11.0000

1

1

**\*D3508-1\***

Wearplate

\*\*

yl 12/05/01

Location

Loc Qty

Loc Code

FP002

11

72933

11

yl

D3508-3

Manufactured No

260

Each

12.0000

1

1

**\*D3508-3\***

Wearplate

\*\*

yl 12/05/01

Location

Loc Qty

Loc Code

FP001

12

38527

1

81347

11

yl

D3508-5

Manufactured No

260

Each

15.0000

1

1

**\*D3508-5\***

Wearplate

\*\*

yl 12/05/01

Location

Loc Qty

Loc Code

FP001

15

71688

6

72416

9

yl

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 8

Thursday, April 05, 2012 12:57:42 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3508-7

Manufactured No

260

Each

12.0000

1

1

**\*D3508-7\***

Wearplate

\*\*

yl nlo5101

Location

Loc Qty

Loc Code

FP001

12

76265

12

D3558-1

Manufactured No

260

Each

9.0000

1

1

**\*D3558-1\***

Gasket

\*\*

yl nlo5101

Location

Loc Qty

Loc Code

FP002

9

50925

1

D3558-3

Manufactured No

260

Each

13.0000

1

1

**\*D3558-3\***

Gasket

\*\*

yl nlo5101

Location

Loc Qty

Loc Code

FP

12

82312

12

FP002

1

D3558-5

Manufactured No

260

Each

11.0000

1

1

**\*D3558-5\***

Gasket

\*\*

yl nlo5101

Location

Loc Qty

Loc Code

FP002

11

75255

11

Thursday, April 05, 2012 12:57:42 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Thursday, April 05, 2012 12:57:42 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

D3558-7 Manufactured No

260 Each 9.0000 1 1

\*\*

yl 12/05/01

**\*D3558-7\***

Gasket

Location Loc Qty Loc Code

FP002 9

75249 9

260 Each 264.0000 2 2

\*\*

yl 12/05/01

NAS1611-007

Purchased No

**\*NAS1611-007\***

O-RING

Location Loc Qty Loc Code

FP001 264

103697 264

260 Each 259.0000 4 4

\*\*

yl 12/05/01

NAS1611-010

Purchased No

**\*NAS1611-010\***

O-RING

Location Loc Qty Loc Code

FP 50

110915 0

120770 50

FP001 209

110915 14

117460 8

118077 1

118612 3

119438 47

120986 50

121166 36

121259 50

y4

Thursday, April 05, 2012 12:57:43 PM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 05, 2012 12:57:43 PM

Work Order ID: 82722

**\*82722\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

260

Each

250.0000

4

4

**\*NAS1611-013\***

O-RING

\*\*

41 12/05/01

Location

Loc Qty

Loc Code

FP001

250

116582

5

117291

2

117887

53

119623

36

120910

4

121166

100

121259

50

vd

AN3C4A

Purchased

No

280

Each

3,020.000

8

8

**\*AN3C4A\***

BOLT

\*\*

LC

Location

Loc Qty

Loc Code

ST350

3020

120187

1982

120769

38

121205

1000

120787

AN960C10L

NAS1149C0332  
R

Purchased

No

280

Each

0.0000

8

8

**\*AN960C10I \***

washer

D3512-1

Manufactured

No

280

Each

5.0000

2

2

**\*D3512-1\***

Wearplate

\*\*

11/21/505

\*\*

LC

Location

Loc Qty

Loc Code

ST500

5

74735

5

8/302

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82722

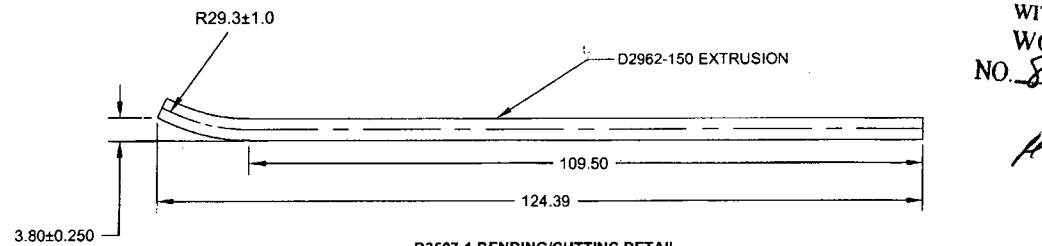
112-045

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

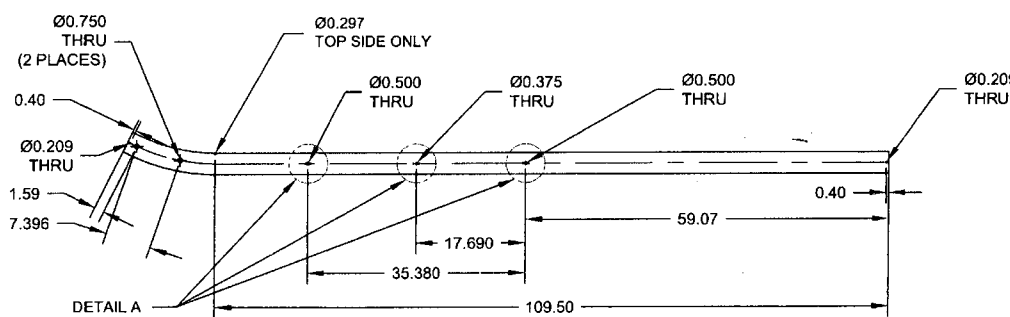
# GENERAL NOTES:

- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

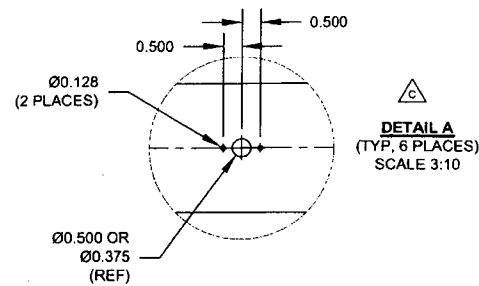
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	EC		
CHECKED	EC	DRAWING NO.	REV. C
MFG. APPR.	EC	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A  
(TYP. 6 PLACES)  
SCALE 3:10

RELEASED  
07.11.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 247

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 66661  
Part number: D135-751-011  
Description: 135 SLID TWR  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[ ] fail[ ]

Qualifier Pat Jones Date of Test Coupon 11/03/17  
Welder Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld